

Work Order ID 129636

February-20-15 1:16:31 PM

129636

Page 1

Item ID: D2893-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support

Stop

NS2

Start Date: 2/20/15

Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/27/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2893

C

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA081
2-Deburr

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DAS
14
9-89

15/03/02

1 29636

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/20/15 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 2/27/15 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

0.00

HandFXtube

Hand Finishing Crosstubes

Memo

Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.
24h of cure time.

Bm 128 292

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

DAS
38
9-89

MAR 03 2015

170

Identify as per dwg & Stock Location: KG 52 0.00

0.00

170

Packaging

Memo

0.00

Packaging

DA
00
9-85

~~MAR 04 2015~~

Work Order ID 129636***129636***

Page 3

Item ID: D2893-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support

Stop

NS2

Start Date: 2/20/15

Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/27/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 15-03-05ME15-3-21

Picklist Print

February-20-15 1:16:30 PM

Page 1

Work Order ID: 129636

129636

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 2/20/15

Required Date: 2/27/15

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: C02.11.26Reformat; Added P/OKJ
 IPP D 06.04.19 removed alodine EC
 IPP Rev:E Added priming as per Rev B 07-04-30 JLM
 IPP F 08.03.19 Re-format EC verified by: DD
 IPP Rev:G 08-05-15 add QC14 DD verified by:EC
 11.08.04 as per dwg rev.C DD verf:EC
 IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	3.0000	0.5	7			

DSK078

D2893-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

3

128465

3

129637

6

JFC 2015-02-26

DART AEROSPACE LTD		Work Order:	1729636
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.990	2.988	2.995	2.995	2.992
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.155	.140	.145	.150	.150
AD	0.040	0.060		.056	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.140	.140	.140	.140	.139
AG	0.140	0.160		.148	.145	.145	.147	.151
AH	1.360	1.400		1.377	1.374	1.378	1.377	1.376
AI	0.040	0.060		.048	.052	.053	.052	.056
AJ	1.190	1.230		1.217	1.216	1.221	1.219	1.223
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.526	2.526	2.526	2.527	2.527
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	JFC / 15-03-01	Date:	2015-02-27
Audited by:	14 9-09	Date:	15/02/02
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	179636
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.983	2.995	2.995	2.994	2.994
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.152	.151	.150	.150	.150
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.142	.141	.143	.145	.144
AG	0.140	0.160		.146	.149	.147	.149	.154
AH	1.360	1.400		1.377	1.376	1.379	1.381	1.376
AI	0.040	0.060		.055	.053	.054	.052	.056
AJ	1.190	1.230		1.222	1.219	1.222	1.223	1.223
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.538	2.538	2.538	2.538	2.538
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>[Signature]</i> 15-03-01	Date:	
Audited by:	DAS 14 9-89	Date:	15/03/02
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	124636
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.991	2.991			
AB	0.440	0.460		.440	.440			
AC	0.125	0.160		.142	.142			
AD	0.040	0.060		.050	.050			
AE	0.188	0.193		.189	.189			
AF	0.125	0.160		.143	.143			
AG	0.140	0.160		.152	.150			
AH	1.360	1.400		1.375	1.379			
AI	0.040	0.060		.053	.056			
AJ	1.190	1.230		1.220	1.224			
AK	0.010	0.020		.015	.015			
AL	0.053	0.073		.063	.063			
AM	0.240	0.260		.250	.250			
AN	2.518	2.538		2.528	2.527			
AO	84.39	90.39		87.39	87.39			
AP	0.261	0.266		.260	.260			
AQ	0.053	0.073		.063	.063			
AR								
AS								
AT								
Accept/Reject								

Measured by:	15-03-01	Date:	
Audited by:	DAS 14 9-89	Date:	15/03/02
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

